

What is claimed is:

1. A method for force-tightly attaching a tubular piece made of elastomeric material to a connecting part, the method comprising the steps of:

- 5 pushing an open end of said tubular piece onto said connecting part;
- positioning a metal clamping ring around said tubular piece at the pushed on end region thereof;
- 10 radially applying a clamping force to said clamping ring to reduce the diameter of said clamping ring and thereby tightly clamping said tubular piece on said connecting part;
- detecting the radial force developed during the clamping operation between said clamping ring and said tubular piece;
- observing and measuring a force/displacement curve during said clamping operation; and,
- 15 utilizing a characteristic feature of said force/displacement curve as a basis for a criterion for switching off the application of said clamping force.

2. The method of claim 1, wherein said tubular piece is a resilient member of an air spring and said connecting part is a cover or a piston of an air spring.

3. The method of claim 1, comprising the further step of ending said clamping operation only when said clamping force begins to drop for the first time after a defined maximum of said curve has been exceeded.

4. The method of claim 1, wherein the maximum of said curve is

only used for evaluation when  $K > K_{min}$  and/or  $d < d_3$  is satisfied as an additional criterion.

5. The method of claim 1, wherein a turning point of said force/displacement curve is used as a switchoff criterion.

6. The method of claim 1, comprising the further step of determining, after the clamping operation, whether the obtained parameter (force/displacement) lies within a defined tolerance band.

7. The method of claim 1, comprising the further step of using a plastic deformable material for said connecting part having a failure elongation which is not exceeded while performing the steps of the method.